

5/29

DART AEROSPACE LTD		Work Order:	23762
Description: Spacer Block Kit		Part Number:	D206-667-011
RF 04.03.22			
Dwg: D3193 Rev. B, DSI 9263 Rev. A		Qty:	8 Kit(s)
BI		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: D206-667-011 Kit consists of (2) D3193-041	JH	05.07.06	8
2	DC	Photocopy bluefile and create labels per PPP D206-667-011 CHG001 WK 27 6.000" (+0.030/-0.000)	DA	05-07-07	8
3	MV 04.03.18	Cut (2) blanks per (1) D206-667-011 Kit Cut blanks: 3.500" x 2.500" x 5.900" long Bar Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 Batch: M18325	YD	05/08/24	8
4	MV	Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1	ML	05.08.24	8
5	QC2	Inspect parts as they come off the CNC machine	ML	05.08.24	8
6	MV	Deburr and Tumble	JH	05/08/24	8
7	QC8	Second check	EP	05-08-26	8
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05 09 07	8
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FL	050913	8
10	QC3	Inspect Powder Coat	ML	050913	8
11	GA 05.07.27 04.03.22	Assemble (2) D3193-041 as per Dwg D3193. (Note: D3193-1 is on BOM as material from Step 3). Pick: Qty Part Number Description Batch 2 D3193-1 Support Bracket B 23762 16 MS20426AD3-5 Rivet M17694 8 MS21073L4 Nut Plate M14397 Identify as D3193-041	SB	05/09/27	8
12	QC5	Inspect work to Step 11	2	05-10-03	8
13	PK	Pick: Packing Kit Qty Part Number Description Batch 2 D3193-041 Spacer Block 8 AN4-6A Bolt 8 AN4-7A Bolt 16 AN960JD416 Washer	ML		
14	QC4	Inspect Kit 100% for completeness on the W/O			
15	PK	Identify and pack for shipping as per PPP D206-667-011 stock	CL	05/10/04	8
16	AC	Cost / part 63.07	542	05-10-18	8
17	DC	Close W/O 63.07 Inspect Level 21	CL	05/10/06	8

Rev	Date	Change	Revised By	Approved
A	04.01.06	New issue	KJ/JLM	JH

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-09-27	11	MS20426 AD3-8 rivet too long for assembly/ Always cracking & going crooked, changed rivet to A - 7 instead.	JB 05/09/27			JB 05.09.29	 05-09-27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:

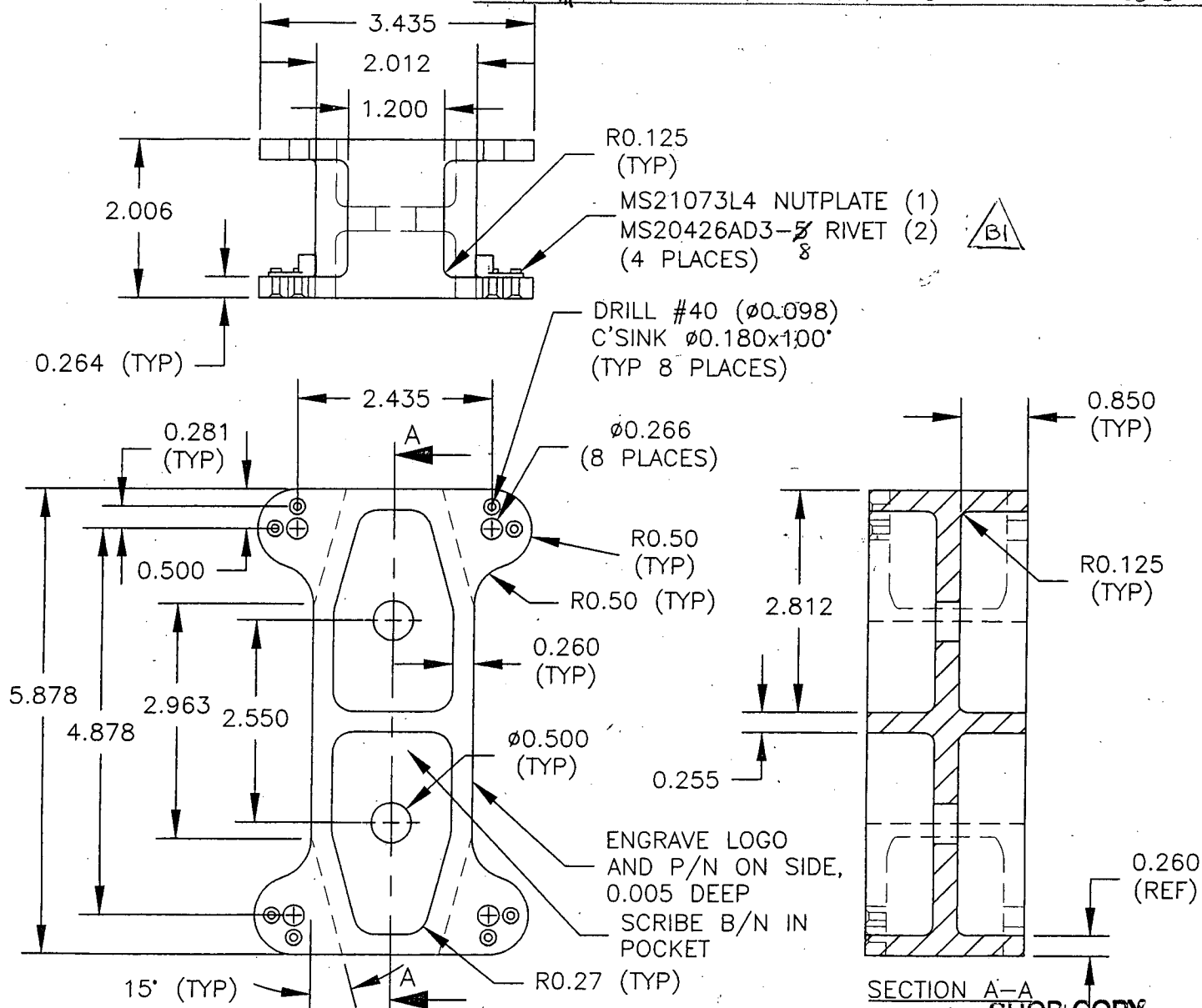
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3193	REV. B SHEET 1 OF 1
DATE	03.12.22			TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09			NEW ISSUE	
B	03.12.22			MANUFACTURED BY DART	
BI	# # 04.03.22			MS20426AD3-8 WAS MS20426AD3-5	

RELEASED
04.01.12 #



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO 23762

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 05, 2005
01:35 pm

Work Order No	: 0023762	Department Code:	
Project Name	: D3193-041	Burden Flags	: NNNNNNNN
Project For	: WK529	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3193-041	Invoice Number	:
Description	: Support Bracket Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 07-05-05		
Est Finish Date	: 07-21-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Roberto Fuentes

From: David Shepherd [davids@dartaero.com]
Sent: Monday, September 26, 2005 1:28 PM
To: Roberto Fuentes
Subject: Re: D3193-041 rivet/ spacedoor

Hi Roberto,

Both of these changes are acceptable to me. Please make sure the relevant drawings are updated accordingly. I can sign when I am there later this week.

David

----- Original Message -----

From: Roberto Fuentes
To: David Shepherd
Sent: Thursday, September 22, 2005 11:20 AM
Subject: D3193-041 rivet/ spacedoor

Hi David,

Two issue,

1) D3193-041 bracket the ipp and dwg call for MS20426AD3-8 rivet very often crack because the only tool access to that area. They try with -7 rivet is better see picture but to get right dia of the mushroom is rivet of the left on -001, on right on the same picture is 0.02 less on dia of the mushroom. See picture call bracket 001 is -7 and 002 is -8 size. It is acceptable to change?

2) Spacedoor was a problem with lever touching the bracket, Dan and I propose to move clamp more closer of the edge of D3163-3 so is leaving 0.125" of the edge of the hole to the edge of plate. Monique open those holes to 0.285" dia. in the plate see picture. If the change make sense to you, we going to try first on the HAI spacedoor.

Thanks,
Roberto

9/26/2005